

Work Order ID **76228**

76228

Graham

Page 1

Monday, November 07, 2011 2:43:54 PM

Item ID: D3414-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 11/7/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: */* Date: *11-07* Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3414	Rev C

100		0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 2.50" x 0.500" x 2.250" long								

110		0.00							
110 <i>perched</i>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3 Dwg Rev <i>issue P10 to Archer</i> Folio Rev <i>machine as per dwg D3414 REV.C</i>								

120		0.00							
120 <i>rec'd</i>									
QC	Memo	0.00							
Quality Control									

*rec'd + inspect for transit damage -
 attach C of C to W10*

11/27/13 (38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 Required Date: 11/16/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check <i>all</i> Memo	0.00 0.00				<i>104</i> (x38)	(x2)		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>W/K</i> Memo	0.00 0.00				(38) <i>02</i>	<i>12-4-23</i>		<i>Pto</i> →
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/4/23</i> <i>DJ</i> <i>11/20/23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

*See NCR
Pink NCR
12-1380*

Part No: DB4143 PAR #: _____ Fault Category: Supplier NCR: Yes No DQA: Just Date: 12/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/4/27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/14/27	#120	Found Qty +2 Parts scrap. R.C. Supplier	CP 12.04.23 PS/BLR	Scrap + Destroy Qty +2 En form supplier to find out what happens	PS 12/04/24	S 12/04/24	CP 12.04.23	S 12/17/23
				Attach. Copy of Reason to who.	CP 12/10/24			

41.16 x 2 = 82.32

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, November 07, 2011 2:43:59 PM

Work Order ID: 76228

76228

Parent Item: D3414-3

D3414-3

Parent Item Name: Lug

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.500X2.500

Purchased

No

100

f

58.1270

0.1875

7.5

~~*M304B0.500X2.500*~~

**

304BAR 500 x 2.50

Location

Loc Qty

Loc Code

MAT050

58.127

112764

8.312

116135

0.375

117685

4.4

119231

45.04

7.6 11/12/13

D3414-3P

X40

11/14/23 (38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

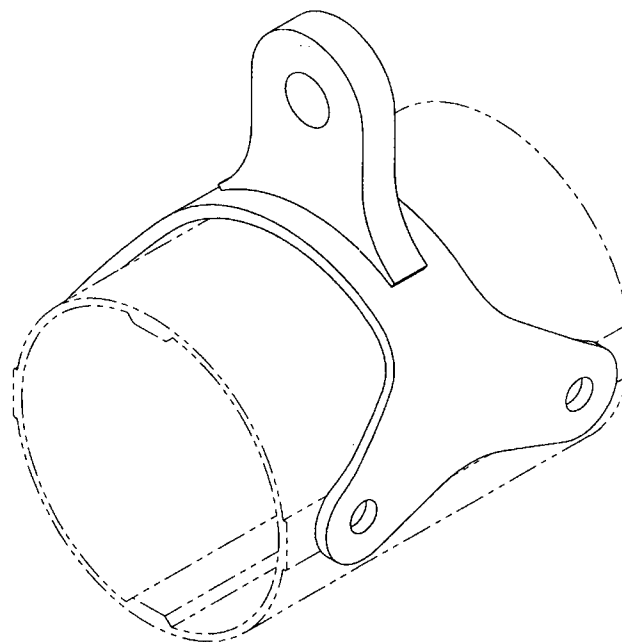
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76228

211107

RELEASED
07/16/2016

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CP</i>		
CHECKED	<i>CP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>CP</i>	D3414	SHEET 1 OF 3
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>CP</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

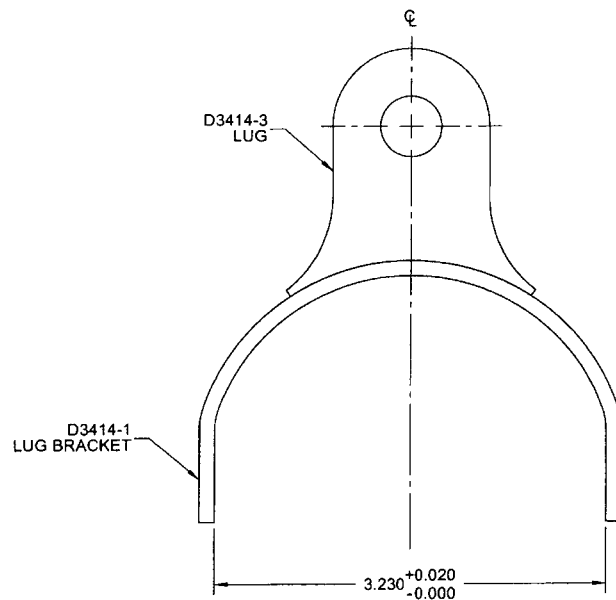
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

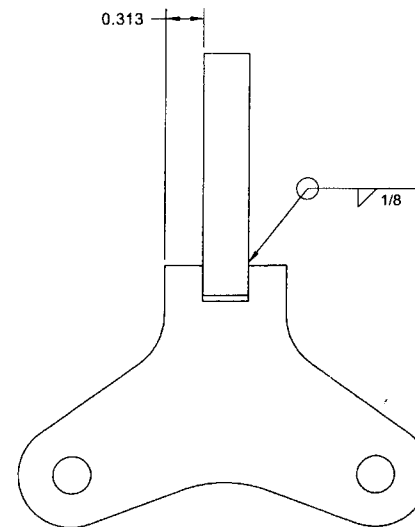
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



76228

RELEASED
04/18/05

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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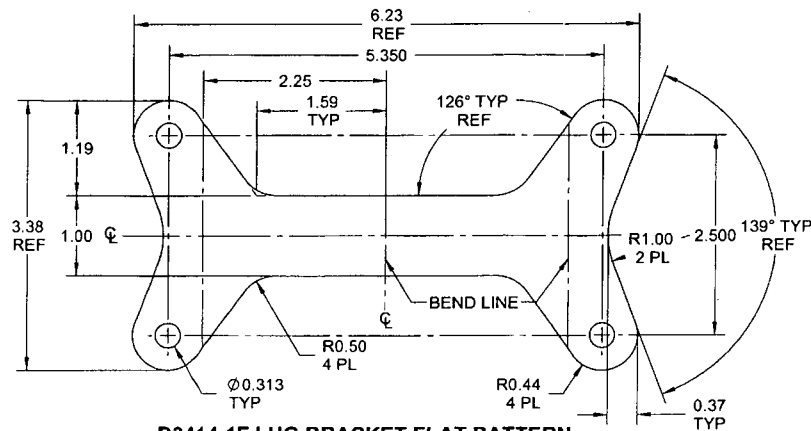
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

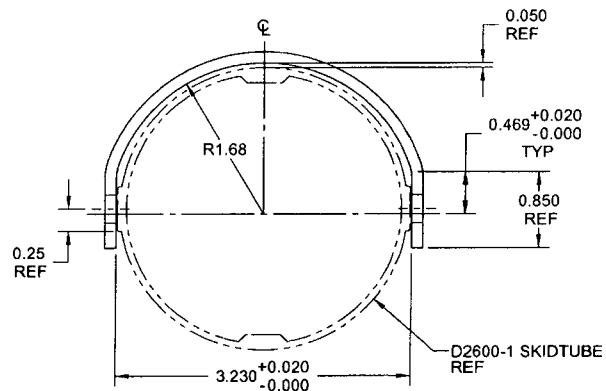
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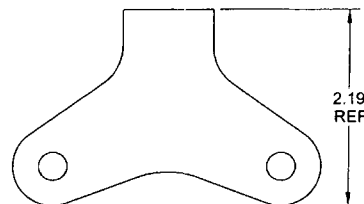
NOTE: Date & initial all entries



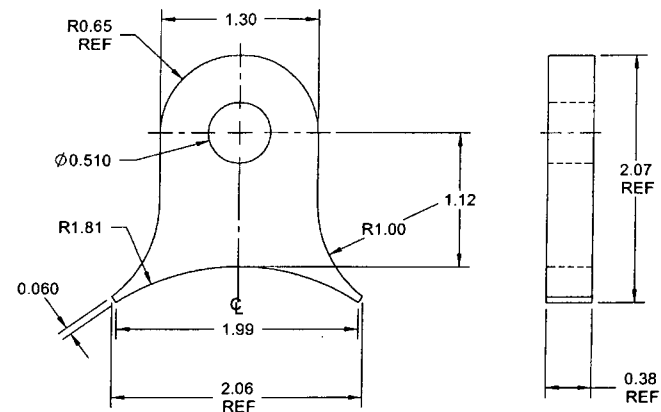
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED





4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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RELEASED

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15679	D3414-3P	38

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle", is written over a horizontal line.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3

Customer Name Dart Aerospace			QTY 40	DWG # D3414-3	REV. C	Part Name LUG		Date 04/13/2012	Lot#	Job # 477-9			
Page 1 of 1			Inspection Interval EVERY 5 PARTS		Special Notes								
Item #	DWG. Dim	Tolerance	Operator	QA First Off	QA Final	5	10	15	20	25	30	35	40
	Rev	C	✓	✓	✓								
	MAT	304/316	✓	✓	✓								
	SUB	NONE	✓	✓	✓								
	Deburr	YES	✓	✓	✓								
1	R0.65	±0.030	PP	✓	✓								
2	1.30	±0.030	1.30	✓	✓	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30
3	Ø0.510	+ .005/- .001	.511	✓	✓	0.510	0.510	.510	.510	.510	.510	.510	.510
4	R1.81	±0.030	PP	✓	✓								
5	0.060	±0.010	PP	✓	✓								
6	1.99	±0.030	PP	✓	✓								
7	2.06	±0.030	2.06	✓	✓								
8	R1.00	±0.030	PP	✓	✓								
9	1.12	±0.030	1.1195	✓	✓								
10	.38	±0.030	.378	✓	✓	371	.378	.3785	.378	.380	.379	.381	.380
11	2.07	±0.030	2.07	✓	✓								



1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
4/19/2012	96

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	4/19/2012	Purolator	Archer	

Qty	Item Code	Description
38	Sales	D3414-3P Lug HST (ON) on sales
Cp 4/23		

Chantal Lavoie

From: alex@archerprecision.ca
Sent: April 24, 2012 10:43 AM
To: Chantal Lavoie
Subject: Re: delivery

Sure Chantal,
On both scrap parts the endmill pulled out of the holder.

Do you have a form for u to fill out for problem reports? If so I could keep them on file here and fill them out with any orders that need them and send them to you with the parts.
Sent from my BlackBerry® phone powered by Koodo Mobile®.

From: "Chantal Lavoie" <clavoie@dartaero.com>
Date: Tue, 24 Apr 2012 10:37:04 -0400
To: 'Alex Mazerolle' <Alex@archerprecision.ca>
Subject: RE: delivery

Hi Alex,
We have rec'd p/o:15679 for D3414-3 but there was 2 scrap. Could you please advise the root cause.
Thanks
Chantal

From: Alex Mazerolle [mailto:Alex@archerprecision.ca]
Sent: April 23, 2012 5:29 PM
To: Chantal Lavoie
Subject: Re: delivery

Good afternoon Chantal,
Sorry for the delay in answering you. The electricians were working on the power so my computer was down most of the day. Your mounts are going on the 5th axis now and I would like to ship the first batch to you by the end of the week. I will give you a detailed schedule tomorrow.

Alex Mazerolle
President
Archer Precision Inc.
Alex@archerprecision.ca
613-899-2405

----- Original Message -----

From: Chantal Lavoie
To: Alex Mazerolle
Sent: Monday, April 23, 2012 8:04 AM
Subject: delivery

Hi Alex,
Could you please give me a update on deliveries dates.
Thanks
Chantal